

SPLIT

Work Order ID 55551 ~~10~~-1

January 20, 2010 11:04:34 AM



Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10

Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2492  
Deburr if necessary

Dwg Rev: F

Prog Rev: f 2-

IR 10-1-21

(5)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IR 10-1-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> S 10/1/12

214

P10 =>

W/O: 55551-3

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/6/12	#120	Took Qty x1 For QC inspection template	S	10/6/12	x1		

Part No: D2492 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Work Order ID 55551

January 20, 2010 11:04:34 AM



Page 2

Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10

Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form using Jig DT2492B

0.00

AND TO FIT  
LITTER

11-07-21  
QSI 042

SB 11/07/20

7

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

11 07 21 7

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

7 BR 11-7-21.

135 large fab.

N/A 11-07-21

PTD



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2492 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>55551-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.25.25	135	<del>Fill in bottom holes w/ weld</del>		<del>No consistency between holes of latter kit + patient stop see 2H2died URU</del>	<del>[Signature]</del>			

*See More signature  
op. 135*

NOTE: Date & initial all entries

# Work Order ID 55551

January 20, 2010 11:04:35 AM



Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 0 M 1107/21

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30

OVEN TEMPERATURE:

302P FINISH TIME:

12:00

7 0 PL 11-7-21

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 0 M 1109/21

# Work Order ID 55551

January 20, 2010 11:04:35 AM



Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location:

G-A

0.00

Memo

w/o  
70227  
(7x)

0.00

SP 11/17/22 (7)

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/1/25

MF  
11-07-22

# Picklist Print

January 20, 2010 11:04:33 AM

Page 1  
T

Work Order ID: 55551



Parent Item: D2492

Parent Item Name: Patient Stop

Start Date: 1/20/10

Required Date: 1/29/10

Comments: IPP E 00.06.26 Removed P/O for powder coat EC  
IPP Rev:F Now 6061-T6 06-06-23 JLM  
IPP Rev:G now water jet 07-12-11 DD

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M6061T6S.080		Purchased	No			100	sf	178.9597	19.1884			



6061-T6 .080 Sheet

B 10-1-21

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

178.95967

110630

35.0136

112141

0.86727

112763

6.85

113438

136.2288

(15)

113438



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

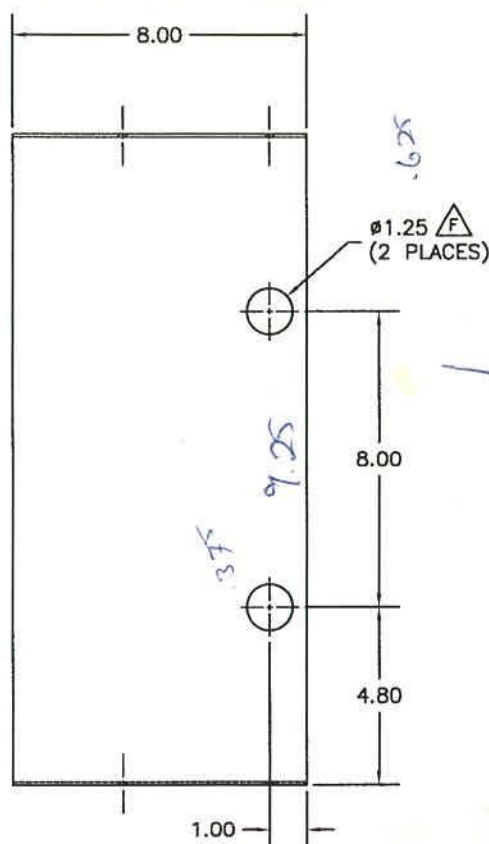
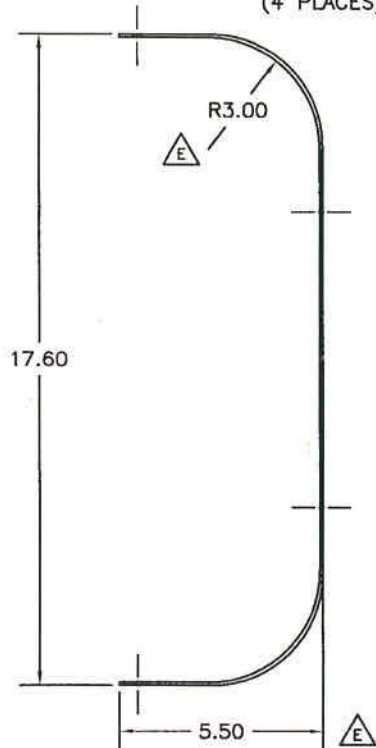
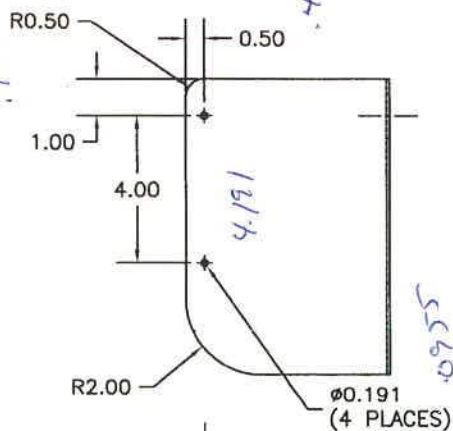
**NOTE:** Date & initial all entries





**DART**

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**RELEASED**06.09.14 *[Signature]***Copyright © 1995 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



# Under Review Notification

Raised By: C Provencal  
Date: 10.05.20

Product #: D350-616  
Product Name: Litter Kit

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2492	Patient Stop				N	Y	N	Y	Y	Y	Y	10-577	Quarantine stock, rework per instructions
D2493	Patient Stop Assembly				N	Y	N	Y	Y	Y	Y	10-577	below, OK to ship after rework.
D315-616-011	Full Litter Kit				N	Y	N	N	Y	Y	Y	10-577	Get ENG sign off to produce more, with lower hole removed.

## Description of issue:

- Location of holes in litter kit for installation of patient stop has no consistency between batches.
- Lower hole from D2492 Patient Stop will be removed. As part of assembling litter kit, patient stop will be drilled to match litter. For replacement parts, customer will transfer drill patient stop to fit litter.
- Rework existing stock of D2492/D2493 patient stops to remove lower hole. Any patient stops already in kits that fit their litter are OK as-is.
- Ensure for any D315-616-011 in stock that the patient stop fits the litter.

## Distribution:

General Manager  
Production Manager  
Director Quality Assurance  
Design Manager  
Chief Engineer

Production Engineering Coordinators  
Quality Assurance Coordinator  
Quality Control Coordinator  
Order Processing  
Customer Technical Support

Engineering Project Managers  
Engineering Clerk  
Marketing